



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9711

Job Sheet 213655



Part No: 646.9711

Job Qty: 60 pcs

Part Name: Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/20

Job Tracking No:

Due Date: 11/30/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.9700 REV.J IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD IPP REV:B 2020.05.27 AS PER
DWG REV.J DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	60 pcs		11/6/20	0.00	1.87	Bandsaw - 1		<i>SL 20-10-22</i>
110	HAAS 5 Axis	60 pcs		11/9/20	0.50	24.00	HAAS - 1 - 5 - B4B HAAS - 2 - 5 - B4B		<i>SL 20-10-22</i>
120	QC 2	60 pcs		11/9/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		<i>SL 20-10-22</i>
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S307784



Part: 646.9711

Job No: 213655

Serial No/Batch: S307784

Revision: Rev.J

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/22/20

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					QC 2 - 66		
					QC 2 - 64		
					QC 2 - 65		
					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
					QC 2 - 76		
					QC 2 - 86		
					QC 2 - 83		
					QC 8 - 12		
					QC 8 - 14		
					QC 8 - 17		
QC 8 - 20							
QC 8 - 25							
QC 8 - 3							
QC 8 - 32	J.C.L. 20-10-22						
QC 8 - 33							
QC 8 - 35							
QC 8 - 39							
QC 8 - 4							
QC 8 - 44							
QC 8 - 45							
QC 8 - 49							
QC 8 - 58							
QC 8 - 8							
QC 8 - 9							
QC 8 - 68							
QC 8 - 67							
QC 8 - 1 (A)							
QC 8 - 47							
QC 8 - 40							
QC 8 - 52							
QC 8 - 23							
QC 8 - 57							
QC 8 - 76							
QC 8 - 61							
QC 8 - 66							
QC 8 - 73							
QC 8 - 82							
140 Outsource - 1 - Heat Treat	60 pcs	11/28/20			MEI001-VC	15	OCT 23 2020
150 Packaging 2-1 - Receive - B4B	60 pcs	11/28/20	0.00	0.00	Packaging 2 - 1 - B4B		
					Packaging 2 - 2 - B4B		
					Packaging 2 - 3 - B4B		
					Packaging 2 - 5 - B4B		
					Packaging 2 - 4 - B4B		
					Packaging 2 - 6 - B4B		
					Packaging 2 - 7 - B4B		
					Packaging 2 - 8 - B4B		
					Packaging 2 - 9 - B4B		
					Packaging 2 - 10 - B4B		
					Packaging 2 - 11 - B4B		
					Packaging 2 - 12 - B4B		
					Packaging 2 - 13 - B4B		
					Packaging 2 - 14 -		
					Plex 10/1/20 10:21 AM		Dart.lajeunesse.marie

				B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155 QC 6	60 pcs	11/28/20	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	81
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	
				QC 6 - 82	
160 Spray Paint - 2 - B4B	60 pcs	11/30/20	0.00 2.00	Spray Paint - 1 - B4B	DAS
				Spray Paint - 2 - B4B	87
				Spray Paint - 3 - B4B	NOV 03 2020
				Spray Paint - 4 - B4B	9-89
170 QC 14	60 pcs	11/30/20	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	DAS
				QC 14 - 51	81
				QC 14 - 58	9-89
				Plex 10/1/20 10:21 AM Dart.lajeunesse.marie	

				QC 14 - 59				
				QC 14 - 9				
				QC 14 - 68				
				QC 14 - 40				
				QC 14 - 19				
				QC 14 - 43				
				QC 14 - 24				
				QC 14 - 61				
				QC 14 - 81				
				QC 14 - 82				
				QC 14 - 87				
				QC 14 - 47				
				185 Packaging 3-1 - Stock - B4B	60 pcs	11/30/20	0.00 0.00	Packaging 3 - 1 - B4B
Packaging 3 - 2 - B4B								
Packaging 3 - 3 - B4B								
Packaging 3 - 4 - B4B								
Packaging 3 - 5 - B4B								
Packaging 3 - 6 - B4B								
Packaging 3 - 7 - B4B								
Packaging 3 - 8 - B4B								
Packaging 3 - 9 - B4B	NOV 05 2020							
Packaging 3 - 10 - B4B								
Packaging 3 - 11 - B4B								
Packaging 3 - 12 - B4B								
Packaging 3 - 13 - B4B								
Packaging 3 - 14 - B4B								
Packaging 3 - 15 - B4B								
Packaging 3 - 16 - B4B								
Packaging 3 - 17 - B4B								
Packaging 3 - 18 - B4B								
Packaging 3 - 19 - B4B								
Packaging 3 - 20 - B4B								
Packaging 3 - 21 - B4B								
Packaging 3 - 22 - B4B								
Packaging 3 - 23 - B4B								
Packaging 3 - 24 - B4B								
Packaging 3 - 25 - B4B								
Packaging 3 - 26 - B4B								
Packaging 3 - 27 - B4B								
Packaging 3 - 28 - B4B								
Packaging 3 - 29 - B4B								
Packaging 3 - 30 - B4B								
								Plex 10/1/20 10:21 AM Dart.lajeunesse.marie

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					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
190 QC 21 - SA	60 pcs	11/30/20	0.00	0.00	QC 21 - SA - 21	DAS 21
					QC 21 - SA - 70	9-09 NOV 05 2020
					QC 21 - SA - 9	
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 100 - (Bandsaw) Cut Blank at 4.625"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB135 FOLIO REV-AB

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Outsource process - Heat Treat) PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

160 - (Spray Paint / NDT Room) ***THIN COAT OF PRIMER*** PRIME AS PER DWG, SEE NOTE #4 S 265114

170 - (QC14- Inspect Spray Paint)

185 - (Identify as per dwg & Stock Location: CK197

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	23.1600 ft (.386 ea)	100-Bandsaw - 1	S299116 S305850

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MSTEEL-A2-B0.500X1.250	23	14	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB047429



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB047429

PO Date: 10/23/20

Due Date: 10/30/20

Purchase Order

Revision:

Revision Date:

Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	213655	646.9711	646.9700 Rev.J	Blade : Various STC's (Outsource process - Heat Treat) PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed <i>X60</i>	-	10/30/20	60 pcs	0 pcs NOV 03 2020	60 pcs	\$4.666/pcs	\$279.96 <i>119</i>
Grand Total:												\$279.96



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB047429



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Please ensure to send the related invoice to hby_ap@dartaero.com.

Plex 11/3/20 10:13 AM dart.lussier.patrick

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
347796	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
POHB047429	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results

HARDNESS

58 - 62 HRC

11

60 - 61 HRC

(807)

DAS
81
9-89

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
60	18	646.9711 (60) 646.9711 JOB 213655 1 BC EPS

APPROUVÉ

3 NOV

COMMENTAIRES / comments

MET
71

APPROUVÉ par / Approved by:

Alexandre Demuyt

DATE: 2020-10-29

METCOR INC.

500 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 8A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
347796	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
POHB047429	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	11 (907)	60 - 61 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
60	18	646.9711 (60) 646.9711 JOB 213655 1 BC EPS

COMMENTAIRES / comments



APPROUVÉ par / Approved by:

Alexandre Demuyt

DATE: 2020-10-29

3 NOV

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
347796	1	148939

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À / Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
POH047429		A2	2020/10/23	CLIENT

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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60 646.9711 18,
(60) 646.9711 JOB 213655
1 BC EPS

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BC EPS	1	

EXPÉDIÉ PAR: Shipped by:	
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QUANTITÉ EXPÉDIÉE / Quantity Shipped : 60

POIDS EXPÉDIÉ / Weight Shipped : 18,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

1 Box
Fax: 779-4779-8557

RECEIVED

NOV 02 2020

DART AEROSPACE LTD.

APPROUVÉ

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 60

POIDS EXPÉDIÉ / Weight Shipped : 18,00

Signature:

Date: